

Work Order ID 85427

June-07-12 2:54:55 PM

85427

Page 1

Item ID: D2583

Revision ID:

Item Name: Latch Bracket

Start Date: 07/06/2012 Start Qty: 40.00

Required Date: 14/06/2012 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B					(46)			
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet									
SCSD - 240									
	Memo								
	1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

B1267

B1267

counted
(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

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Revision ID:

Stop *NS2*

Item Name: Latch Bracket

Start Date: 07/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

DeburrForm on CNC Brake as per Dwg D2583

46

JB
12/06/12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

46

M/ 12-06-12

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

46X

M/ 12/06/13

W/O:		WORK ORDER CHANGES					
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40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating M121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:45 FINISH TIME: 11:15 3200F	0.00				46X			md 12/06/13
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				46			B12613
180 *180* Packaging Packaging	Identify as per dwg & Stock Location 5511 Memo	0.00				46			545 12/6/13

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/6/14
MLJ 12/06/13

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Picklist Print

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Page 1

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85427

Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 07/06/2012

Required Date: 14/06/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	123.9000	0.1169	4.922105			

M5052H32S 040

5052-H32 .040 Sheet

**

B12-6-7

Location

Loc Qty

Loc Code

MAT022

123.9

117130

4.4

118641

64

119384

23

121192

32.5

(46)

121192

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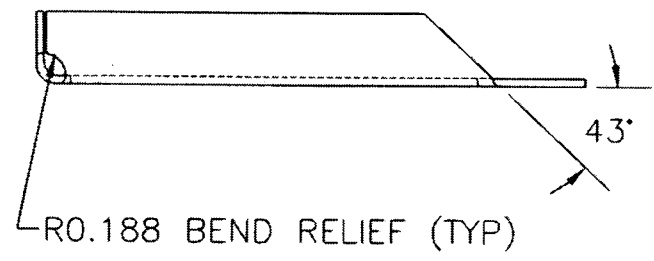
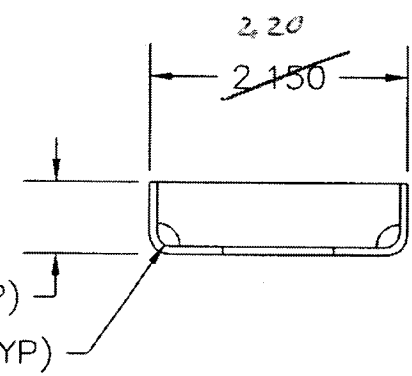
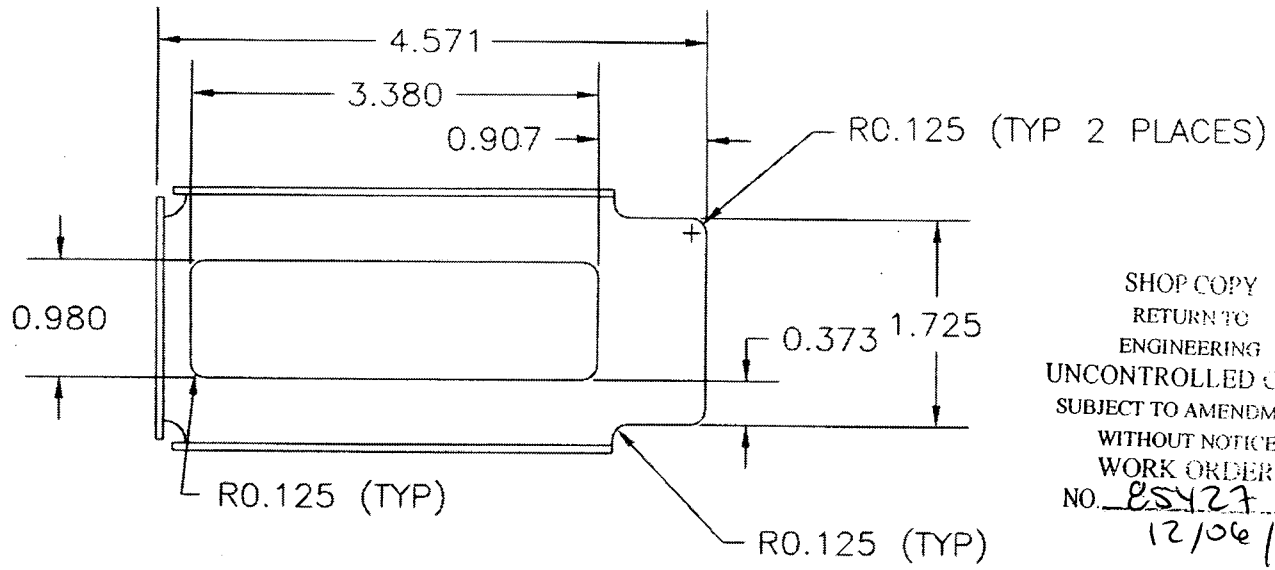
DART



RELEASED
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85427 MLJ
12/06/07 KE 99.02.26

DESIGN	MIKE M.	DRAWN BY	RE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B
		SCALE	2:3	SHEET 1 OF 1
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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